

Work Order ID 116517

April-17-14 7:46:14 AM

116517

Page 1

Item ID: D4834-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Leg Assembly, LH
 Start Date: 4/17/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/02/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-04-17 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4834	<u>14.06.18</u>								

110		0.00				2	FF		NOV 28 2014
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110

Small Fab

Small Fab

Memo

ALIGN PILOT HOLES IN D4834-1 WITH PILOT HOLES IN D4805-3 AND D4805-5. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9955 AS PER DWG.

120	QC5- Inspect part completeness to step on W/O	0.00				2			DAS 38 9-89
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120

QC

Quality Control

Memo

NOV 28 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>* Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	* Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 116517

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Page 2

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 Revision ID: Stop ***NS2***
 Item Name: Leg Assembly, LH
 Start Date: 4/17/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/02/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						<u>2</u>	<u>FF</u>		<u>DEC 02 2014</u>
Small Fab	Memo	0.00							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9955 A/R HYSOL BATCH: <u>M43 130450</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						<u>(2)</u>			<u>DAS 38 9-89</u>
QC	Memo	0.00							
Quality Control									<u>DEC 02 2014</u>
150	Identify as per dwg & Stock Location: <u>S130</u>	0.00							
150						<u>(2x)</u>			<u>DAS 46 9-89</u>
Packaging	Memo	0.00							
Packaging									<u>DEC 02 2014</u>

antiscure

P/O: 26707

RJL

C214/12/10 3 2

rec'd.

Sp 15-01-7.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 116517

116517

Page 3

Item ID: D4834-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Leg Assembly, LH

Start Date: 4/17/14 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 5/02/14 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MJ 15-01-09

St 130 CR 1501-08

15-1-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

April-17-14 7:46:16 AM

Page 1

Work Order ID: 116517

116517

Parent Item: D4834-041

D4834-041

Parent Item Name: Leg Assembly, LH

Start Date: 4/17/14

Required Date: 5/02/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.01.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL20PB5-8 *HL20PB5-8* Rivet		Purchased		No			Each	76.0000		8			
									**		FF	NOV 26 2014	
* HL32PB5-8 Location 129865 Loc Qty Loc Code													
			ST281					66		8			
					M128110			6					
					M128579			60					
			ST284					10					
					M128429			10					
D4805-3 *D4805-3* End Fitting		Manufactured		No	116511		Each	2.0000		2			
									**	2	FF	NOV 26 2014	
Location 112024 Loc Qty Loc Code													
			ST123					2		2			
					112023			2					
D4805-5 *D4805-5* End Fitting		Manufactured		No			Each	2.0000		2			
									**		FF	NOV 26 2014	
Location 116519 Loc Qty Loc Code													
			ST123					2		2			
					112024			2					
D4834-1 *D4834-1* Strut		Manufactured		No			Each	0.0000		2			
									**		FF	NOV 26 2014	

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

April-17-14 7:46:16 AM

Page 2

Work Order ID: 116517

116517

Parent Item: D4834-041

D4834-041

Parent Item Name: Leg Assembly, LH

Start Date: 4/17/14

Required Date: 5/02/14

Start Qty: 2.00

Required Qty: 2.00

HL86-5

Purchased

No

Each

133.0000

8

HI 86-5

FF DEC 02 2014

Collar

Location

Loc Qty

Loc Code

ST280

129864

33

M128110

33

ST284

100

M128228

100

0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26707

Purchase Order Date 12/3/2014

PO Print Date 12/3/2014

Page Number 1 of 6

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
1	117147	D4802-041 LEG ASSEMBLY	12/5/2014 Yes 12/5/2014		2.00	\$4.00	\$8.00
	LASER MARKED						
						Line Total:	\$8.00
2	122437	D4804-041 BIPOP ASSEMBLY	12/5/2014 Yes 12/5/2014		1.00	\$4.00	\$4.00
	LASER MARKED						
						Line Total:	\$4.00
3	116517	D4834-041 LEG ASSEMBLY	12/5/2014 Yes 12/5/2014		2.00 ✓	\$4.00	\$8.00
	LASER MARKED						

SP15-01-7

Note:

12/3/2014



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE Dec 22, 2014

P.O NUMBER 2026737

ITEM DESCRIPTION**QUANTITY****COMMENTS**

D4802-041 LEG ASSEMBLY 2 ALL ITEMS HAVE BEEN LASER MARKED

D4804-041 BIP OP ASSEMBLY

D4834-041 LEG ASSEMBLY 2 ✓

D4835-041 LEG ASSEMBLY 4

D4836-041 LEG ASSEMBLY 2

D4836-041 LEG ASSEMBLY 2

D4866-041 LEG ASSEMBLY 1

D4866-042 LEG ASSEMBLY 1

D4866-042 LEG ASSEMBLY 1

D4867-041 LEG ASSEMBLY 2

D4878-041 LEG ASSEMBLY 2

D4880-041 LEG ASSEMBLY 2

D4881-041 LEG ASSEMBLY 1

D4881-042 LEG ASSEMBLY 2

SPIS OK